

Work Order ID 94310

\*94310\*

Page 1

December-06-12 11:48:41 AM

Item ID: D3177-043

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Bracket

Start Date: 12/06/12 Start Qty: 2.00

\*2\*

Cust Item ID:

Required Date: 12/13/12 Req'd Qty: 2.00

\*2\*

Customer:

Reference:

Approvals: Process Plan: ✓ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3177	Rev B2

100	BAND SAW	0.00							
*100*									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blank: 47.40" x (12.000" +0.100/-0.000)								

SL 12-12-10

2 0

110	HAAS CNC VERTICAL MACHINING #1	0.00							
*110*									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Machine part as per Folio FA291 and Dwg D3177.Deburr								

PO 12-12-17

2 0

120	QC2- Inspect parts off machine FAI/FAIB	0.00							
*120*									
QC	Memo	0.00							
Quality Control									

PO 12-12-17

2 0

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Item ID: D3177-043 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Bracket  
 Start Date: 12/06/12 Start Qty: 2.00 \*2\* Cust Item ID:  
 Required Date: 12/13/12 Req'd Qty: 2.00 \*2\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00				2			
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				2			
150 *150* Small Fab Small Fab	Small Fab  Memo Press D3177-5 Spacers as shown on Dwg D3177	0.00  0.00							

SMD  
12/12/19

2

# Work Order ID 94310

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Item ID: D3177-043 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Bracket  
 Start Date: 12/06/12 Start Qty: 2.00 \*2\* Cust Item ID:  
 Required Date: 12/13/12 Req'd Qty: 2.00 \*2\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00				2	0	12-12-20	
*160*									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 2:10 OVEN TEMPERATURE: FINISH TIME: 2:40								
170	QC3- Inspect Part Finish	0.00				2	0	12-12-21	
*170*									
QC	Memo	0.00							
Quality Control									
180	Small Fab	0.00				2	0	12-12-21	
*180*									
Small Fab	Memo	0.00							
Small Fab	Assemble as per Dwg D3177								

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Item ID: D3177-043 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Bracket  
 Start Date: 12/06/12 Start Qty: 2.00 **\*2\*** Cust Item ID:  
 Required Date: 12/13/12 Req'd Qty: 2.00 **\*2\*** Customer:

## Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 <b>*190*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00 DAS 15 9-89 12.12.21				2			
200 <b>*200*</b> Packaging Packaging	Identify as per dwg & Stock Location: <u>5T167</u>  Memo	0.00 0.00				2			12/12/21 JB
210 <b>*210*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							12/11/10 JF MF 12-12-28

# Picklist Print

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Page 1

Work Order ID: 94310

Parent Item: D3177-043

Parent Item Name: Bracket

Start Date: 12/06/12

Required Date: 12/13/12

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev: B03.01.27 Added Step 12KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD10 Washer	NAS1149D0363J	Purchased	No	122378		180	Each	0.0000	3	6		FF 12-12-21	
BLRS-010 Pip Pin		Purchased	No			180	Each	36.0000	1	2		FF 12-12-21	

## Location

## Loc Qty

## Loc Code

FG

4

121374

4

ST283

32

118207

1

120178

2

122730

29

2

D2690-6

Manufactured

No

180

Each

30.0000

1

2

FF 12-12-21

Lanyard Assembly

## Location

## Loc Qty

## Loc Code

GA

3

91957

3

ST014

27

90568

2

91642

1

92559

4

92739

6

92867

4

93401

10

2

D2690-6RevB2

Manufactured

No

180

Each

0.0000

1

2

Lanyard Assembly

D3177-5

Manufactured

No

180

Each

13.0000

4

8

Spacer

## Location

## Loc Qty

## Loc Code

ST032

13

20295

13



<b>D3065-5DART AEROSPACE LTD</b>		<b>Work Order:</b> 943W
<b>Description:</b> Bracket		<b>Part Number:</b> D3177-3
<b>Inspection Dwg:</b> D3177	<b>Rev:</b> B2	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.970	+0.010/-0.000	.980	✓		VERN	P40-01
R0.125	+/-0.010	.125	✓		R 6	
0.700	+0.010/-0.000	.700	✓		Mic	P40-02
0.188	+0.010/-0.000	.196	✓		"	118-120
10.776	+/-0.005	10.776	✓		VERN	CNC-02
R0.625	+/-0.010	.625	✓		R G.	
Ø0.261	+0.005/-0.000	.262	✓		VERN	P40-01
0.200	+/-0.010	.200	✓		"	"
Ø0.203	+0.005/-0.000	.206	✓		"	"
Ø0.625	+0.001/-0.000	.626	✓		Mic	P40-02
3.733	+0.000/-0.005	3.732	✓		VERN	P40-01
0.575	+/-0.010	.571	✓		"	"
0.700	+0.010/-0.000	.700	✓		Mic	P40-02
0.970	+0.010/-0.000	.974	✓		Mic	118-120



<b>Measured by:</b> PG	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 12-12-17	<b>Date:</b> 12/12/19	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue	P/O D3177-041/-043 KJ/RF [Signature]	[Signature]

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RELEASE  
03-01-21  
JF



DESIGN	DATE	CHECKED	APPROVED	DRAWING NO.	REV. B
03.01.07	03.01.07			D3177	SHEET 1 OF 3
BRACKET				SCALE 1:5	
A	02.12.03	NEW ISSUE			
B	03.01.07	RE-DESIGN			

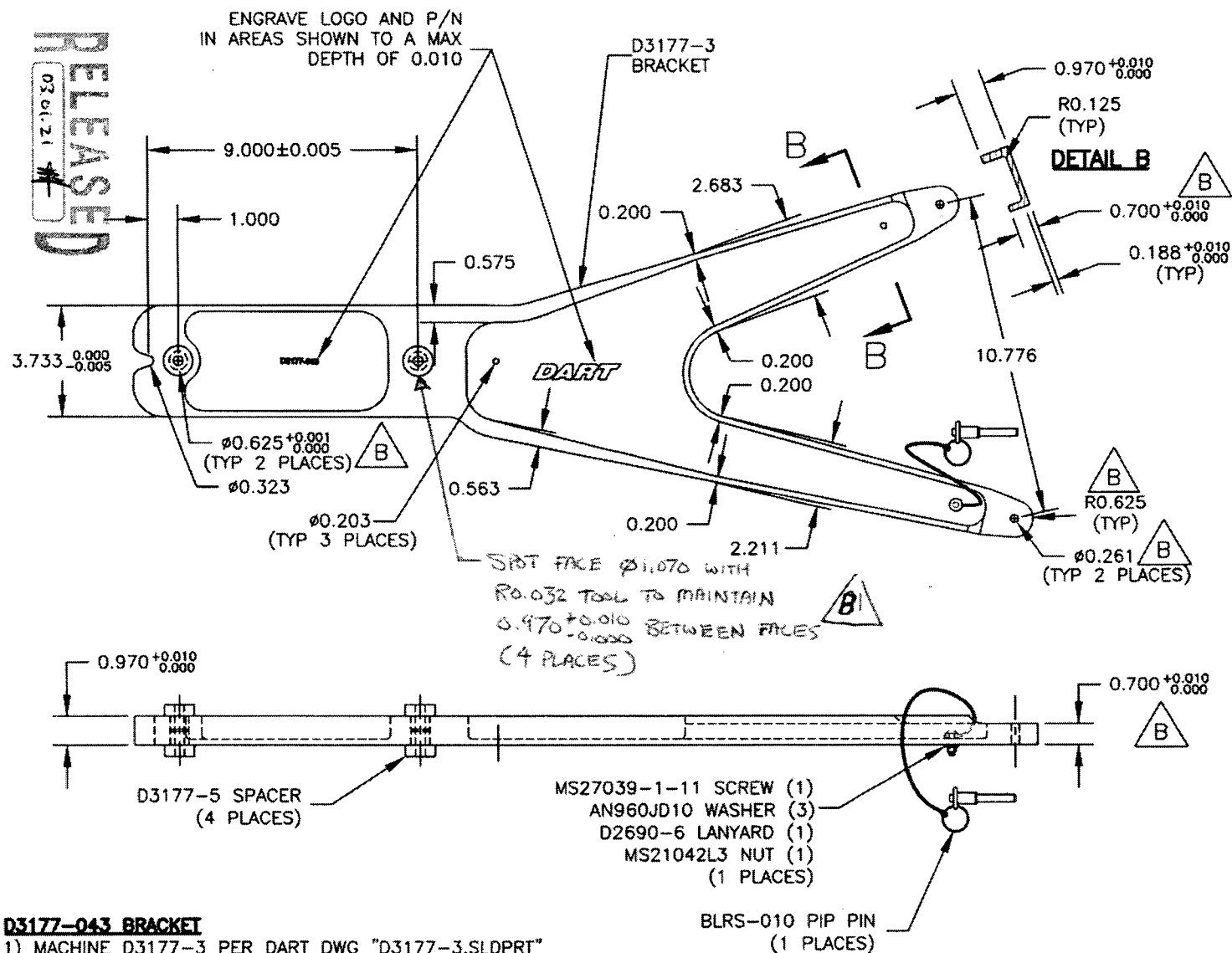
**D3177-041 BRACKET**

- 1) MACHINE D3177-1 PER DART DWG "D3177-1.SLDPRT"  
MATERIAL: 6061-T6 ALUMINUM BAR (QQ-A-250/11 OR QQ-A-200/8)  
(REF DART SPEC. M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 (PRIOR TO ASSEMBLY)  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3 (AFTER ASSEMBLY)
- 4) TOLERANCES ARE PER QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES



036121

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**D3177-043 BRACKET**

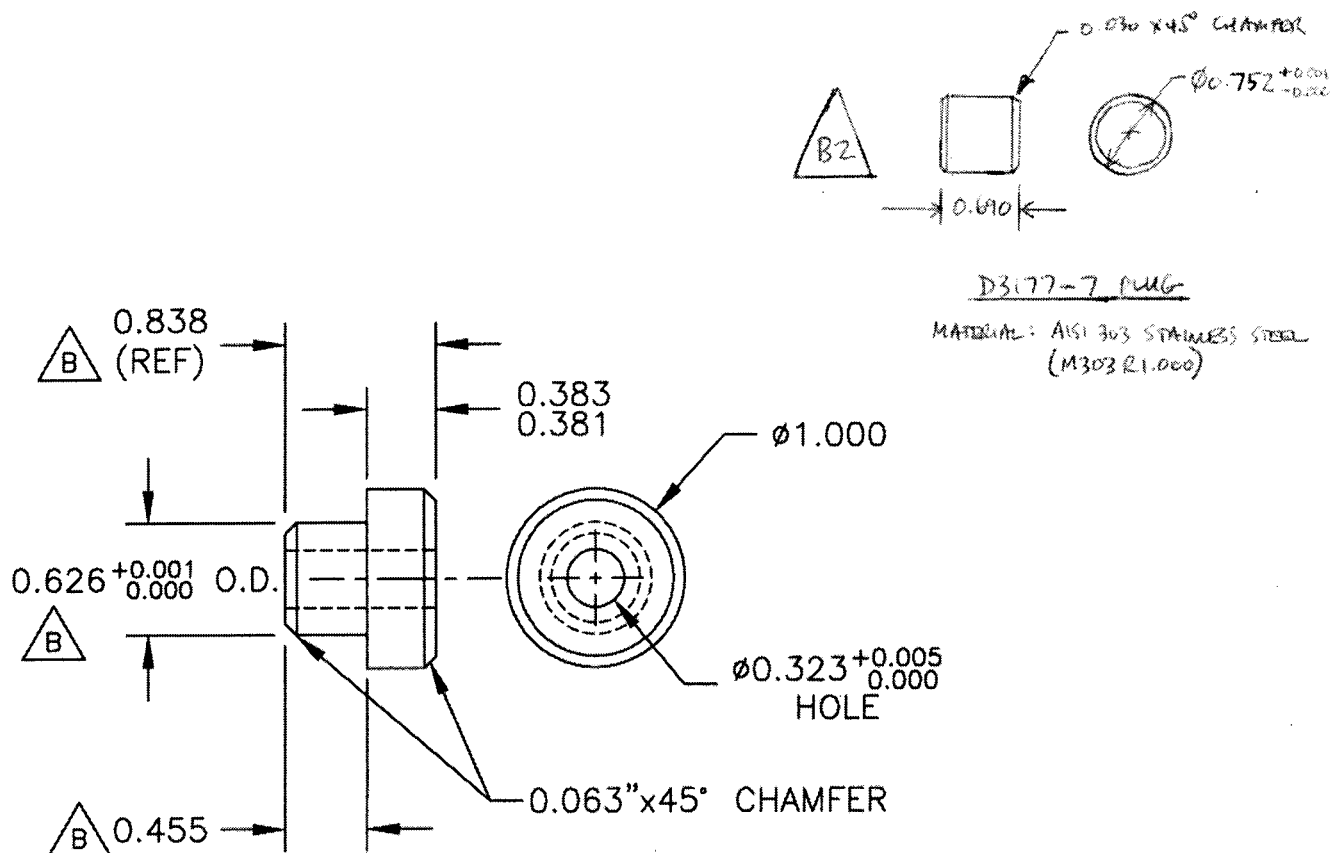
- 1) MACHINE D3177-3 PER DART DWG "D3177-3.SLDPRT" (1 PL)  
MATERIAL: 6061-T6 ALUMINUM BAR (QQ-A-250/11 OR QQ-A-200/8)  
(REF DART SPEC. M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 (PRIOR TO ASSEMBLY)  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3 (AFTER ASSEMBLY)
- 4) TOLERANCES ARE PER QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

**DART**

DESIGN	DRAWN BY	DARI AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. 8
CHECKED	APPROVED	DRAWING NO.	SHEET 2 OF 3	
DATE		TITLE	SCALE	
03.01.07		BRACKET	1:5	



DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3177	REV. B SHEET 3 OF 3
DATE 03.01.07		TITLE BRACKET	SCALE 1:1



### D3177-5

- 1) MATERIAL: 6061-T6 ALUMINUM BAR  $\phi 1.000$   
(QQ-A-200/8 OR QQ-A-225/8)  
(REF DART SPEC. M6061T6R1.000)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

RELEASED  
03 01 21 *[Signature]*

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